

GARY

# Work Order ID 73357



Wednesday, August 31, 2011 11:38:21 AM

Item ID:	D4030-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Long Basket Assembly (350)					
Start Date:	8/31/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	9/12/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CL</u>	Date:	<u>11/08/31</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D4030	C								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110	Assemble as per dwg	0.00							
HandFinish	Memo	0.00							
Hand Finishing	****Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label ****								
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

11/12/11

1 of 11/09/12

5/10/12

(H)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 73357**

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Item ID: D4030-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Assembly (350)

Start Date: 8/31/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/12/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo	0.00 0.00	PP	73357		11/9/23			
140  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							11/9/27 mf 11-09-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, August 31, 2011 11:38:18 AM

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1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the work.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete them.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress to ensure that the objectives are being met.

5. The final step is to evaluate the results of the project. This involves assessing the outcomes against the objectives and identifying any areas for improvement or further action.

\_\_\_\_\_

**Required Date:** 9/12/2011

**Required Qty: 1.00**

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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\_\_\_\_\_

Placard, Max Load

**Loc Code**

ST122

8

66275

8

ST124

1

64869

1

D2530

Manufactured	No
--------------	----

100	Each	11.0000
-----	------	---------



\_\_\_\_\_

### Handle Weldment

**Loc Code**

ST506

10

72166

10

ST508

1

69318

1

D2535

Manufactured	No
1	1
2	1
3	1
4	1
5	1
6	1
7	1
8	1
9	1
10	1
11	1
12	1
13	1
14	1
15	1
16	1
17	1
18	1
19	1
20	1
21	1
22	1
23	1
24	1
25	1
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82	1
83	1
84	1
85	1
86	1
87	1
88	1
89	1
90	1
91	1
92	1
93	1
94	1
95	1
96	1
97	1
98	1
99	1
100	1

100	Each	85.0000
-----	------	---------

[illegible]

Spring

Loc Code

ST504

85

71117

85

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Wednesday, August 31, 2011 11:38:18 AM

Page 2

Work Order ID: 73357

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 8/31/2011

Required Date: 9/12/2011

Start Qty: 1.00

Required Qty: 1.00

D2537  
Bushing

Manufactured No

100 Each

29.0000

2

2

Location

Loc Qty

Loc Code

ST504

29

29

71853

D3913-041  
Long Basket Base Assembly, 350

Manufactured No

100 Each

0.0000

1

1

D3914-041  
Long Basket Lid Assembly (350)

Manufactured No

100 Each

0.0000

1

1

D3917-3  
Washer

Manufactured No

100 Each

13.0000

6

6

Location

Loc Qty

Loc Code

ST092

13

13

72142

D3953-3  
Gas Spring Stud, Lid

Manufactured No

100 Each

16.0000

2

2

Location

Loc Qty

Loc Code

ST096

16

16

71875

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Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 73357

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 8/31/2011

Required Date: 9/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3953-7  
Spring Spacer

Manufactured No

100 Each

13.0000 2

Location

Loc Qty

Loc Code

ST096

13

65053

4

71885

9

D3953-9  
Gas Spring Washer

Manufactured No

100 Each

16.0000 2

Location

Loc Qty

Loc Code

ST096

16

69025

4

71869

12

D3953-17  
Gas Spring Spacer

Manufactured No

100 Each

4.0000 2

Location

Loc Qty

Loc Code

ST096

4

71870

4

D3953-19  
Gas Spring Bracket

Manufactured No

100 Each

4.0000 1

Location

Loc Qty

Loc Code

ST096

4

59213

1

68462

3

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 4

Work Order ID: 73357



Parent Item: D4030-041



Parent Item Name: Long Basket Assembly (350)

Start Date: 8/31/2011

Required Date: 9/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3953-21	Manufactured	No	100	Each	3.0000	1	1
Gas Spring Bracket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST096	3	
68463	3	

D3969-3	Manufactured	No	100	Each	4.0000	1	1
Spring (Basket Lid)							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST272	4	
64285	1	
68925	3	

AN3-14A	Purchased	No	100	Each	76.0000	4	4
Bolt							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST352	76	
117872	76	

AN3-16A	Purchased	No	100	Each	173.0000	2	2
Bolt							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST352	173	
117441	73	
118628	100	

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, August 31, 2011 11:38:19 AM

Page 5

Work Order ID: 73357

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 8/31/2011

Required Date: 9/12/2011

Start Qty: 1.00

Required Qty: 1.00

AN5-17A

Purchased

No

100

Each

114.0000

4



Bolt

Location

Loc Qty

Loc Code

ST337

20

118422

20

ST339

94

117872

44

118706

50

AN4-12

Purchased

No

100

Each

72.0000

3



Bolt

Location

Loc Qty

Loc Code

ST357

72

117514

22

118626

50

AN310-4

Purchased

No

100

Each

39.0000

3



NUT

Location

Loc Qty

Loc Code

ST324

39

118112

39

AN310C4

Purchased

No

100

Each

47.0000

2



Nut

Location

Loc Qty

Loc Code

ST324

47

116741

4

117395

13

118090

10

118626

20

Wednesday, August 31, 2011 11:38:19 AM

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 6

Work Order ID: 73357

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 8/31/2011

Required Date: 9/12/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

100

Each

1,777.000

6



Nut

Location

Loc Qty

Loc Code

ST300

1777

117441

160

117601

400

117885

217

118451

1000

6

MS21042L5

Purchased

No

100

Each

1,076.000

4



Nut

Location

Loc Qty

Loc Code

ST300

1076

116105

5

116548

53

117441

432

117611

90

118179

496

7

MS24665-151

Purchased

No

100

Each

418.0000

3



Cotter Pin

Location

Loc Qty

Loc Code

ST309

418

17566

418

3

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Wednesday, August 31, 2011 11:38:19 AM

Work Order ID: 73357

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 8/31/2011

Required Date: 9/12/2011

Start Qty: 1.00

Required Qty: 1.00

MS24665-300

Purchased

No

100

Each

248.0000

2



Cotter Pin

Location

Loc Qty

Loc Code

GA

200

118234

200

ST309

48

116823

48

NAS1149F0432P

Purchased

No

100

Each

82.0000

6



Washer

Location

Loc Qty

Loc Code

ST275

82

117291

8

118612

74

NAS1149F0563P

Purchased

No

100

Each

180.0000

4



Washer

Location

Loc Qty

Loc Code

ST297

180

117735

180

NAS1149F0332P

Purchased

No

100

Each

174.0000

8



WASHER

Location

Loc Qty

Loc Code

ST275

174

117735

75

118354

96

17317

3

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Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Page 8

Wednesday, August 31, 2011 11:38:19 AM

Work Order ID: 73357



Parent Item: D4030-041



Parent Item Name: Long Basket Assembly (350)

Start Date: 8/31/2011

Required Date: 9/12/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0432R

Purchased

No

100

Each

4,542.000

2



11/9/11

Washer

Location

Loc Qty

Loc Code

ST297

4542

117291

4542

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

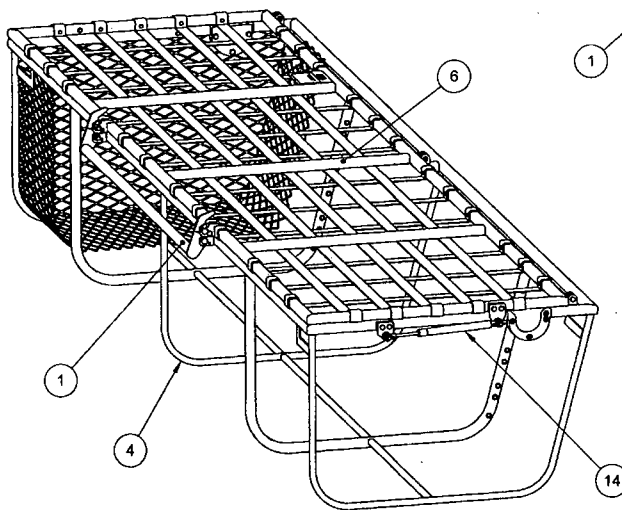
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

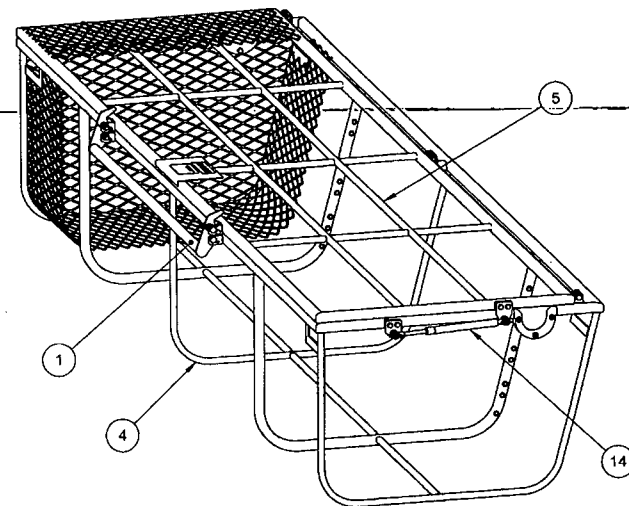
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1		D3914-041	LONG BASKET LID ASSY (350)
6		1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8	8	NAS1149F0332P	WASHER
31	2	2	NAS1149C0432R	WASHER



**D4030-043 LONG BASKET ASSY, LIGHT LID (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)



**D4030-041 LONG BASKET ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 73357

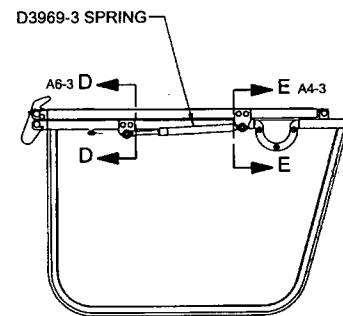
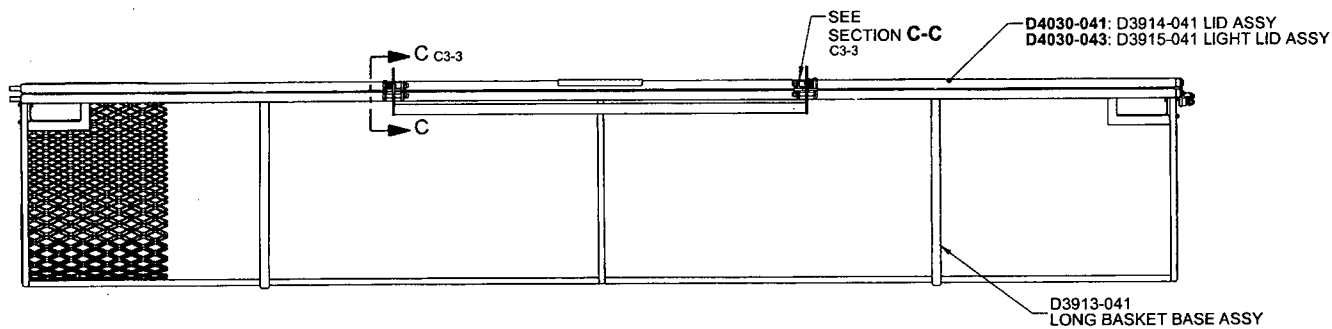
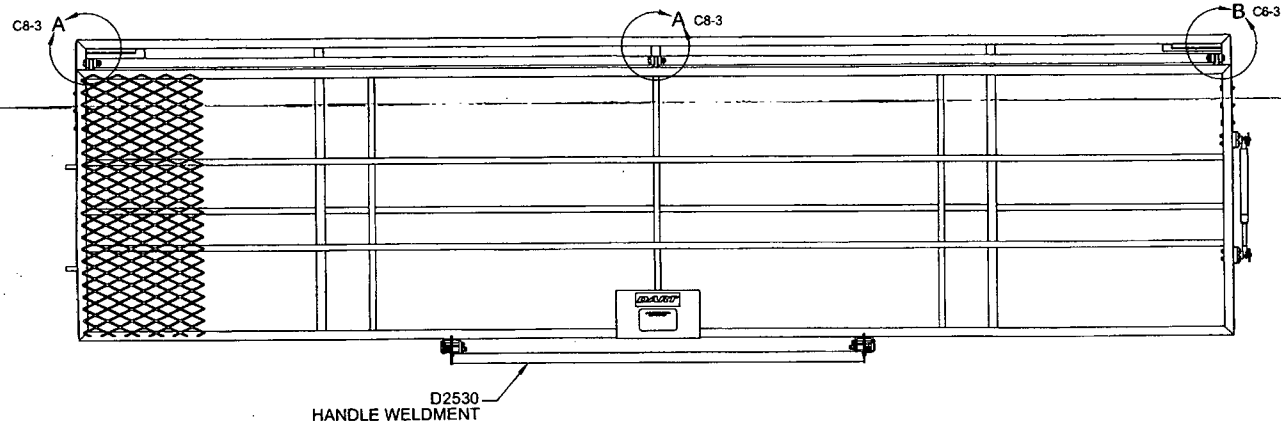
RELEASED  
10-08-12  
ECN 10-596

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 72 lbs APPROX  
-043: 57 lbs APPROX

C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (88-1); QTY FOR ITEM #3 WAS 4 (D8-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP		
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JFS	D4030	SHEET 1 OF 3
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	LONG BASKET ASSY (350)	NTS
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8 7 6 5 4 3 2 1



**D4030-041 LONG BASKET ASSY (350)** (SHOWN)  
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

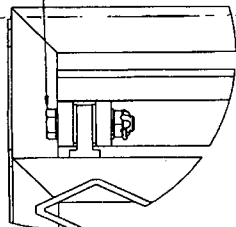
**D4030-043 SHORT BASKET ASSY, LIGHT LID (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**RELEASED**  
10.08.17

DESIGN	AS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	SES	D4030	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET ASSY (350)	NTS
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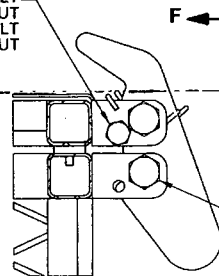
8 7 6 5 4 3 2 1

AN4-12 BOLT  
D3917-3 WASHER, 2X  
NAS1149F0432P WASHER, 2X  
AN310-4 NUT, CASTELLATED  
MS24665-151 COTTER PIN



**DETAIL A** D8-2  
D5-2

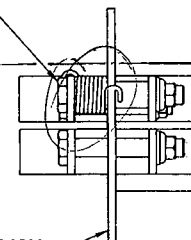
D4030-041: AN3-16A BOLT  
MS21042L3 NUT  
D4030-043: AN3-20A BOLT  
MS21042L3 NUT



**SECTION C-C** B4-2  
B6-2

D4030-041: AN5-17A BOLT  
D2537 BUSHING  
D2535 SPRING  
NAS1149F0563P WASHER  
MS21042L5 NUT

D4030-043: AN5-21A BOLT  
D2537 BUSHING  
D2535 SPRING  
NAS1149F0563P WASHER  
MS21042L5 NUT



**VIEW F-F** C3-3

D2530  
HANDLE WELDMENT  
REF

D3953-17 GAS SPRING SPACER  
D3953-21 GAS SPRING BRACKET  
AN3-14A BOLT  
NAS1149F0332P WASHER, 2X  
MS21042L3 NUT  
2 PL

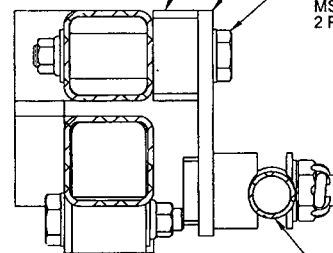
D3953-3 GAS SPRING STUD, LID  
D3953-7 GAS SPRING SPACER  
D3953-9 GAS SPRING SPACER  
NAS1149C0432R WASHER  
AN310C4 NUT, CASTELLATED  
MS24665-300 COTTER PIN

D3969-3 SPRING  
REF

**SECTION D-D** B2-2

D3953-17 GAS SPRING SPACER  
D3953-19 GAS SPRING BRACKET

AN3-14A BOLT  
NAS1149F0332P WASHER, 2X  
MS21042L3 NUT  
2 PL



D3953-3 GAS SPRING STUD, LID  
D3953-7 GAS SPRING SPACER  
D3953-9 GAS SPRING SPACER  
NAS1149C0432R WASHER  
AN310C4 NUT, CASTELLATED  
MS24665-300 COTTER PIN

D3969-3 SPRING  
REF

**SECTION E-E** B1-2

**RELEASED**  
10.08.124

DESIGN	415	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D4030</b>	REV. C OF 3
MFG. APPR.	JFS	TITLE	SHEET 3 OF 3
APPROVED		SCALE	
DE APPR.		<b>LONG BASKET-ASSY (350)</b>	NTS
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